

Work Order ID 54877

January 04, 2010 1:21:58 PM



Page 1

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Item Name: MONOPOD ASSEMBLY

2 MF

Start Date: 1/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-01-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3686	Rev C
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100



Packaging

Packaging

Pick Kit

0.00

110



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Use anti-seize compound Tectyl 502c Class 1,Mil-PRF-16173E or equivalent
on thread and assemble as per dwg D3686

(2)

2-Assemble D3693-1 & D3691-1 &D3693-3 &D3688-7 Using Sikaflex -241/-
291 between mating surfaces as per Dwg D3686
***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686

SJ 10/01/25

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ S100125

0.00

(XZ)

130



Packaging

Packaging

Identify as per dwg & Stock Location: 19

0.00

Memo

0.00

10-125 24sp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/2010

MF 10-1-25

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Parent Item: D3686-041



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3688-7		Manufactured	No			110	Each	15.0000	1.0000			

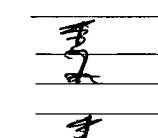
STUD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	15
44686	1
46055	5
46699	2
50931	7



SB 10/01/25

D3689-1



Manufactured No

110 Each 21.0000 1.0000

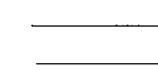


Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2
46051	2



SB 10/01/25

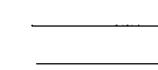
SLEEVE

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2
46051	2



D3691-1



Manufactured No

110 Each 0.0000 1.0000



STUD

B 54859

SB 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3692-1



Manufactured

No

110

Each

642.0000

4.0000



SPACER

Warehouse

Location

Main Warehouse

ST	55
44827	8
45672	14
50325	33

Main Warehouse

ST127	587
50736	179
51467	408

D3692-3



Manufactured

No

110

Each

57.0000

4.0000



SPACER

Warehouse

Location

Main Warehouse

ST	57
44690	57

SB 10/01/25

8

8

SB 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 54877



Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3693-1



Manufactured

No

110

Each

73.0000

1.0000



Rod End Bearing

Warehouse

Location

Main Warehouse

ST

Loc Qty

5

45723

5

Main Warehouse

ST127

Loc Qty

68

50733

7

50734

61

Sb 10/01/25

2

D3693-3



Manufactured

No

110

Each

13.0000

1.0000



Rod End Bearing

Warehouse

Location

Main Warehouse

ST

Loc Qty

6

45724

1

50723

5

2 8 10/01/25

Main Warehouse

ST127

Loc Qty

7

50723

7

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3C10A



Purchased

No

110

Each

66.0000

2.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

66

102116

7

105940

39

112489

20

AN3C12A



Purchased

No

110

Each

350.0000

2.0000



Bolts

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

350

112314

350

4 SB 10/01/25
4 SB 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3686-041



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-3

Purchased

No

110

Each

4,542.000

4.0000

Nut



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 4462

111819 70

112243 29

112314 4363

S1 10/01/25

8

NAS509L12C

Purchased

No

110

Each

85.0000 1.0000



Nuts



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 85

106993 2

112314 73

112828 10

S1 10/01/25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: MONOPOD ASSEMBLY

Start Date: 1/5/2010

Required Date: 1/25/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-12C		Purchased		No		110	Each	126.0000	1.0000			

Nuts

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	126	
106993	7	
110844	10	
112453	109	

Ss 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

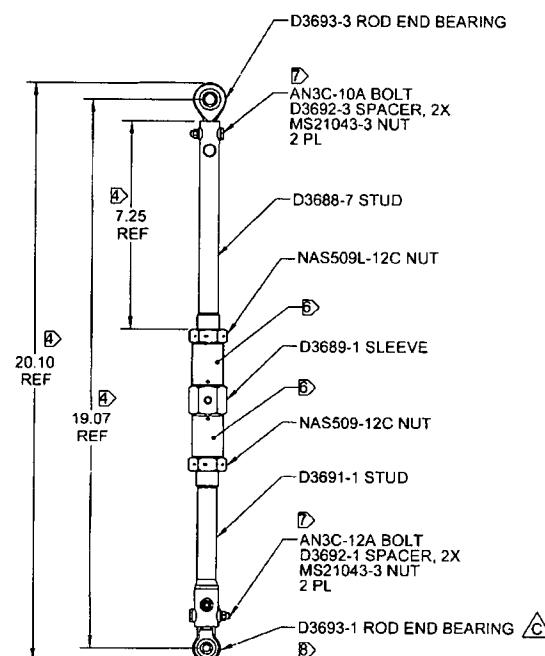
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)		RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS		RF	08.11.24
A	NEW ISSUE		RF	08.05.22
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>[Signature]</i>	DRAWING NO. D3686 REV. C		
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 1		
APPROVED	<i>[Signature]</i>	TITLE SCALE		
DE APPR.	<i>[Signature]</i>	MONOPOD ASSEMBLY NTS		
DATE	08.12.15			

RELEASED
(09/01/12 AM)

C
B
A
A

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